

# Work Order ID 75118

October 17, 2011 2:38:10 PM

**\*75118\***

Page 1

Item ID: D2662-2 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH In 206

Start Date: 19/10/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 10.00 **\*10\*** Customer:

Reference: *SL 11-10-17*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev D								

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.  
 Inspect part number and batch number are programmed

*SL 11-10-31*

*(10)*

MACHINE AS PER FOLIO FB069 & DWG

DWG REV: *D*

FOLIO REV: *AA*

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet *→*

*SL 11-10-31*

*10*

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Item ID: D2662-2 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
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Required Date: 16/11/2011 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SL	11-10-31		10	0		
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	ML	11/10/31		10	0		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				10	0	BL 11-10-31	

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Item ID: D2662-2 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH In 206  
 Start Date: 19/10/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*150\***

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

10X  $\phi$  M-14/10/31

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Quality Control

Memo

0.00

10X  $\phi$  M-14/10/31  
counted

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

Packaging

Memo

0.00

11/11/11 100

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Item ID: D2662-2

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Saddle, RH In 206

Stop \*NS2\*

Start Date: 19/10/2011 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

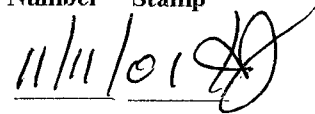
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

11/11/01   
MF 11-11-01

# Picklist Print

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Page 1

Work Order ID: 75118

Parent Item: D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 19/10/2011

Required Date: 16/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	4.0000	1	10		11-10-30	

Location

Loc Qty

Loc Code

MAT040

4

66965

1

69677

2

73768

1

73779

~~73780~~

10  
~~73780~~

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b> D2662-2	
<b>Inspection Dwg:</b> D2662 Rev. D		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.120	.121	.121	.120	
B	0.100	0.140		.135	.134	.133	.131	.134	
C	1.125	1.145		1.139	1.139	1.140	1.140	1.139	
D	0.615	0.685		.680	.680	.680	.680	.680	
E	0.240	0.260		.249	.248	.247	.248	.248	
F	1.313	1.343		1.325	1.325	1.325	1.325	1.325	
G	0.210	0.230		.220	.221	.220	.220	.220	
H	0.100	0.180		.135	.135	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.579	1.579	1.580	1.580	1.579	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.113	.113	.113	.113	.113	
M	0.990	1.010		.990	.990	.990	.990	.990	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.005	6.005	6.005	6.005	6.005	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.313	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.799	.799	.800	.799	.799	
W	0.540	0.560		.550	.550	.550	.551	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.924	.922	.923	.923	.922	
AA	0.490	0.510		.502	.502	.503	.502	.502	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	11-10-30

Audited by:	<i>[Signature]</i>
Date:	11/10/31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 78118
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b> D2662-2
<b>Inspection Dwg:</b> D2662 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1/6	2/4	3/8	4/9		
A	0.100	0.140		-120	-120	-121	-120	121	
B	0.100	0.140		-133	-133	-133	-133	-133	
C	1.125	1.145		1.140	1.140	1.139	1.140	1.140	
D	0.615	0.685		-680	-680	-680	-680	-680	
E	0.240	0.260		-248	-248	-248	-248	-248	
F	1.313	1.343		1.325	1.325	1.325	1.324	1.324	
G	0.210	0.230		-220	-220	-220	-220	-220	
H	0.100	0.180		-135	-135	-135	-135	-135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.580	1.580	1.579	1.580	1.580	
K	0.235	0.240		-238	-238	-238	-238	-238	
L	0.100	0.120		-113	-113	-113	-113	-113	
M	0.990	1.010		-990	-990	-990	-990	-990	
N	0.510	0.515		-512	-512	-512	-512	-512	
O	5.990	6.010		6.005	6.005	6.005	6.005	6.005	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		-313	-313	-313	-313	-313	
S	0.315	0.322		-316	-316	-316	-316	-316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		-799	-800	-800	-800	-800	
W	0.540	0.560		-551	-550	-551	-551	-551	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		-257	-257	-257	-257	-257	
Z	0.912	0.932		-924	-923	-923	-923	-923	
AA	0.490	0.510		-501	-502	-501	-502	-502	
AB	0.178	0.198		-188	-188	-188	-188	-188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SK
Date:	11-10-30

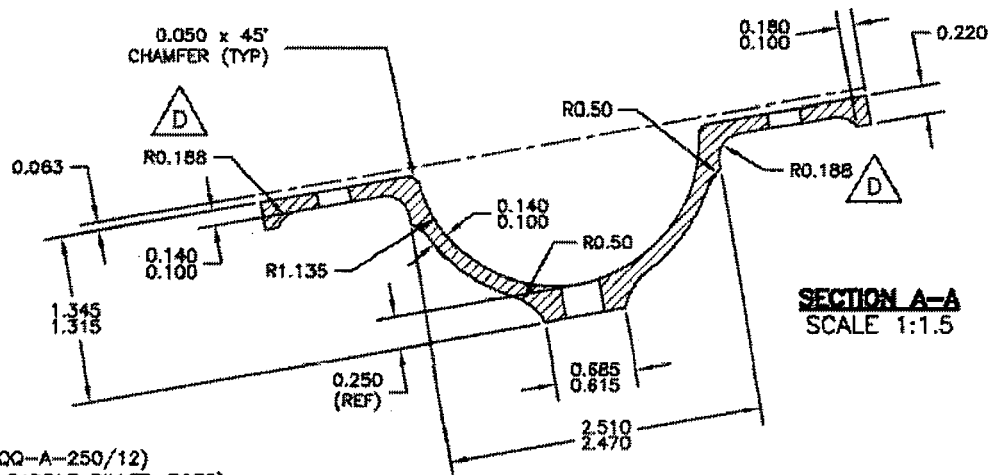
Audited by:	cmx
Date:	11/10/31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



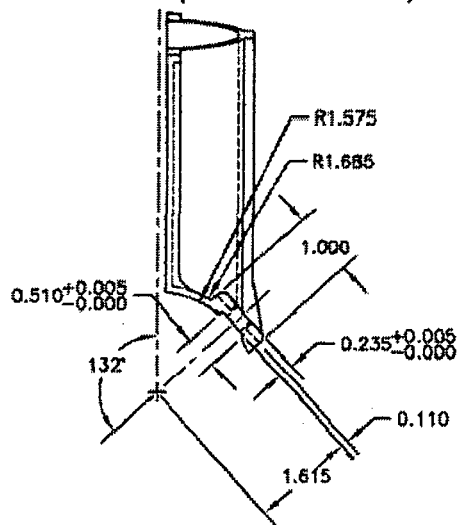
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

RELEASED  
07.02.02

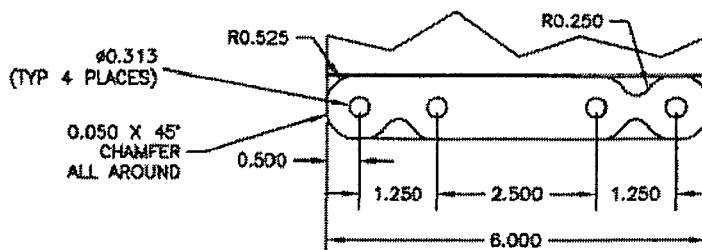
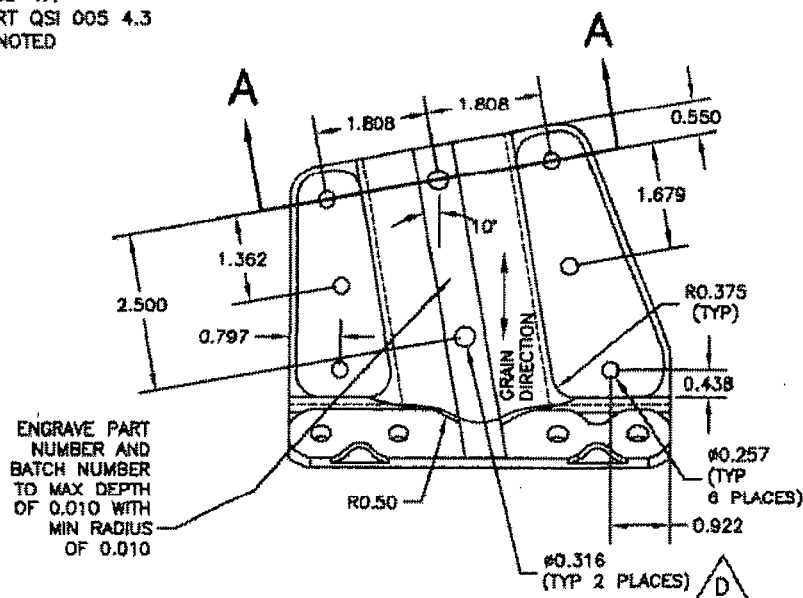


#### NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)



**D2662-1 SADDLE INSIDE**



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